



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**RBEA62310-09**  
**Job Sheet 193398**



Part No: RBEA62310-09

Job Qty: 6 pcs

Part Name: Bottom Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/15/19

Job Tracking No:

Due Date: 5/3/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEA62310 Rev 1A IPP Rev A 18.01.18 New issue DP Verify DD

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation                    | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |             | Sign-off    |
|-------|------------------------------|-------|------------|----------|-----------|---------|-----------------------|-------------|-------------|
|       |                              |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time   |             |
| 110   | Large Fab - Welded Assy-1    | 6 pcs | 5/3/19     |          | 0.00      | 6.00    | Large Fab - 1         |             | MAY 01 2019 |
|       |                              |       |            |          |           |         | Large Fab - 10        |             |             |
|       |                              |       |            |          |           |         | Large Fab - 2         |             |             |
|       |                              |       |            |          |           |         | Large Fab - 3         |             |             |
|       |                              |       |            |          |           |         | Large Fab - 4         | DAS 24 9-89 |             |
|       |                              |       |            |          |           |         | Large Fab - 5         |             |             |
|       |                              |       |            |          |           |         | Large Fab - 6         |             |             |
|       |                              |       |            |          |           |         | Large Fab - 7         |             |             |
|       |                              |       |            |          |           |         | Large Fab - 8         |             |             |
| 120   | QC 9                         | 6 pcs | 5/3/19     |          | 0.00      | 0.00    | Large Fab - 9         |             | DAS 43 9-89 |
|       |                              |       |            |          |           |         | QC 9 - 10             |             |             |
|       |                              |       |            |          |           |         | QC 9 - 18             |             |             |
|       |                              |       |            |          |           |         | QC 9 - 24             |             |             |
|       |                              |       |            |          |           |         | QC 9 - 43             |             |             |
|       |                              |       |            |          |           |         | QC 9 - 50             |             |             |
| 130   | Powdercoat - 13 Yellow - B4B | 6 pcs | 5/3/19     |          | 0.00      | 0.60    | QC 9 - 9              |             | BR 19-5-8   |
|       |                              |       |            |          |           |         | Powdercoat - 1 - B4B  |             |             |
|       |                              |       |            |          |           |         | Powdercoat - 2 - B4B  |             |             |
|       |                              |       |            |          |           |         | Powdercoat - 3 - B4B  |             |             |
| 140   | QC 3                         | 6 pcs | 5/3/19     |          | 0.00      | 0.00    | Powdercoat - 4 - B4B  |             |             |
|       |                              |       |            |          |           |         | QC 3 - 10             |             |             |
|       |                              |       |            |          |           |         | QC 3 - 13             |             |             |
|       |                              |       |            |          |           |         | QC 3 - 15             |             |             |
|       |                              |       |            |          |           |         | QC 3 - 17             |             |             |
|       |                              |       |            |          |           |         | QC 3 - 18             |             |             |
|       |                              |       |            |          |           |         | QC 3 - 2              |             |             |
|       |                              |       |            |          |           |         | QC 3 - 28             |             |             |
|       |                              |       |            |          |           |         | QC 3 - 3              |             |             |
|       |                              |       |            |          |           |         | QC 3 - 30             |             |             |
|       |                              |       |            |          |           |         | QC 3 - 34             |             |             |
|       |                              |       |            |          |           |         | QC 3 - 36             |             |             |



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Container No: S177116



Part: RBEA62310-09

Job No: 193398

Serial No/Batch: S177116

Revision: 1A

Inspector:

Exp Date:

Instructions:

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|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  |                        |                         |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------|-----------------|-------------------------------|------------------|------------------------|-------------------------|
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | QC 3 - 41              |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | QC 3 - 51              |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | QC 3 - 58              |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | QC 3 - 59              |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | QC 3 - 68              |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | QC 3 - 9               | DAS 40                  |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | QC 3 - 40              | MAY 09 2019 9-89        |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | QC 3 - 19              |                         |
| 150                                                                                                                                                                                                                                                                                                                                                                      | Packaging 3-1 - Stock - B4B | 6 pcs           | 5/3/19                        | 0.00 0.00        | Packaging 3 - 1 - B4B  |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 2 - B4B  |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 3 - B4B  |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 4 - B4B  |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 5 - B4B  | DAS 28                  |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 6 - B4B  | 9-89                    |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 7 - B4B  |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 8 - B4B  |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 9 - B4B  |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 10 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 11 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 12 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 13 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 14 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 15 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 16 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 17 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 18 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 19 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 20 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 21 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 22 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 23 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 24 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 25 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 26 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 27 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 28 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 29 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 30 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 31 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 32 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 33 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 34 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 35 - B4B |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | Packaging 3 - 36 - B4B |                         |
| 160                                                                                                                                                                                                                                                                                                                                                                      | QC 21 - SA                  | 6 pcs           | 5/3/19                        | 0.00 0.00        | QC 21 - SA - 21        |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | QC 21 - SA - 70        |                         |
|                                                                                                                                                                                                                                                                                                                                                                          |                             |                 |                               |                  | QC 21 - SA - 53        | DAS 21 MAY 10 2019 9-89 |
| Part Op 110 - (Weld per dwg A/R Steel rod Batch: 135986), Weld as per DWG<br>Descriptions: 120 - (QC9- Inspect visual per QSI004- Fusion Welds)<br>130 - (Powdercoat13 - Yellow #13538), -Mask threads before painting<br>140 - (QC3- Inspect Part Finish)<br>150 - (Identify as per dwg & Stock Location: _____)<br>160 - (QC21- Final Inspection - Work Order Release) |                             |                 |                               |                  |                        |                         |
| <b>Job BOM</b>                                                                                                                                                                                                                                                                                                                                                           |                             |                 |                               |                  |                        |                         |
| <b>Part / Item</b>                                                                                                                                                                                                                                                                                                                                                       | <b>Component Name</b>       | <b>Quantity</b> | <b>Operation</b>              | <b>Container</b> |                        |                         |
| RBEA62310-11                                                                                                                                                                                                                                                                                                                                                             | Bottom Plate                | 6 pcs (1 ea)    | 110-Large Fab - Welded Assy-1 | 5127316          |                        |                         |
| RBEA62310-13                                                                                                                                                                                                                                                                                                                                                             | LH All Thread               | 6 pcs (1 ea)    | 110-Large Fab - Welded Assy-1 | 5127096          |                        |                         |

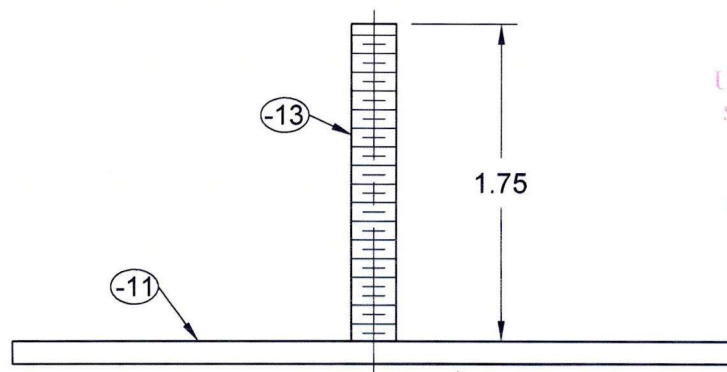
| Job Allocations                    |                |          |           |           |
|------------------------------------|----------------|----------|-----------|-----------|
| Operation                          | Component Part | Required | Inventory | Allocated |
| 110-Large Fab - Welded Assy-1      | RBEA62310-11   | 6        | 18        | 0         |
|                                    | RBEA62310-13   | 6        | 18        | 0         |
| Part Specifications                |                |          |           |           |
| Specifications could not be found. |                |          |           |           |

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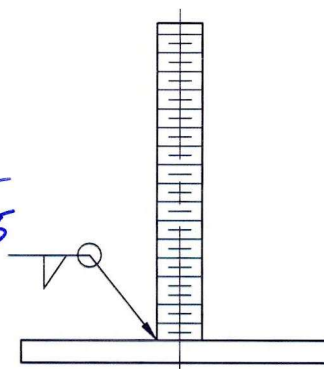


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| REVISIONS |             |      |                  |
|-----------|-------------|------|------------------|
| REV       | DESCRIPTION | DATE | INITIAL APPROVED |
| --        | --          | --   | --               |



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WITHOUT NOTICE  
WORK ORDER  
NO. 193398 M.C.  
19-04-13



(-09)  
BOTTOM  
WELDMENT

|                                                                                                                                                                                                |                                                                                                                                          |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------|
| <b>RED BARN MACHINE</b>                                                                                                                                                                        |                                                                                                                                          |
| <b>TITLE</b><br>AS350/355 ENGINE STRUT                                                                                                                                                         |                                                                                                                                          |
| <b>DWG NO.</b><br>RBEA62310-09                                                                                                                                                                 | <b>REV</b><br>1A                                                                                                                         |
| UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES<br><b>TOLERANCES ON:</b><br>DECIMALS .XXX ± .005<br>.XX ± .01<br>.X ± .1<br>METRIC REF. .XXmm ± .1mm<br>FRACTIONS ± 1/32<br>ANGLES ± 5° | <b>DRAWN BY:</b> PERRITT<br><b>APPROVED:</b> <i>D. Weil</i><br><b>HEAT TREAT:</b><br><b>FINISH:</b> PRIME & PAINT YELLOW<br><b>SPEC:</b> |
| UNLESS OTHERWISE SPECIFIED<br>1. BREAK ALL SHARP EDGES<br>.015 x 45° PR. .015 R<br>2. DIMENSIONAL LIMITS APPLY AFTER PLATING                                                                   | <b>USED ON MODEL:</b><br>EUROCOPTER AS350 & AS355                                                                                        |
| <b>SCALE</b> NTS                                                                                                                                                                               | <b>DATE</b> 3-10-10 <b>SHEET</b> 5 of 7                                                                                                  |

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  | MRB (QS1042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | QC / QA Coordinator    |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |